

Date: Tuesday, 30/09/2008 10:01:51 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	02.750 SUPPORT
Job Number :	42353		
Estimate Number :	10829		
P.O. Number :		Part Number :	D28931
This Issue :	30/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2893 REV B
First Issue :	1/1	Project Number :	N/A
Previous Run :	40781	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JLD 08.9.30	Due Date :	10/10/2008
Comment :	Est: C 02.11.26 Reformat; Added P/O KJ est D 06.04.19 removed alodine EC Est Rev:E Added priming as per Rev B 07-04-30 JLM est F 08.03.19 Re-format EC verified by: DD Est Rev:G 08-05-15 add QC14 DD verified by:EC		

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK078	D2893-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)
 D2893-1 TURNING DETAIL
 Batch: B42259

SS 08/10/14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(20)

Comment: HAAS 1
 Machine as per Folio FA081
 Tumble & Deburr

SS 08/10/14 / DTA

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(20)

Comment: INSPECT ALL DIM TO DIM SHEET

SS 08/10/14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SS 08/10/14 (20)

5.0	POWDER COATING	POWDER COATING
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(20X)

Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
 Mask Inside Bore for Priming

START TIME:

8:15

M-L 08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 10:01:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 42353

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description:

OVEN TEMPERATURE: 400

FINISH TIME: 8:45

MF 08/10/20

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

08-10-20

(20)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

RT 08-10-22

8.0

QC14

INSPECT SPRAY PAINT



08-10-23 (20)



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 08-10-23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42353
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.005	3.005	3.005	3.005	3.003
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.157	.147	.150	.152	.152
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.144	.144	.147	.147	.149
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	1.360	1.400		1.378	1.378	1.370	1.370	1.370
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.205	1.205	1.205	1.205	1.205
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.536	2.536	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>JS</i>	Date: 05/10/14
Audited by: <i>ML</i>	Date: 08/10/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>JS</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42353
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	64	72	83	94	105
HAAS Section								
AA	2.985	3.005		3.003	3.005	3.005	3.002	3.003
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.150	.155	.155	.150	.150
AD	0.040	0.060		.050	.046	.046	.046	.046
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.160	.149	.140	.140	.140
AG	0.140	0.160		.160	.150	.150	.150	.150
AH	1.360	1.400		1.372	1.370	1.370	1.370	1.370
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.206	1.206	1.206	1.206	1.206
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.520	2.520	2.520	2.520	2.520
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>RF</i>	Date: 08/10/15
Audited by: <i>gmk</i>	Date: 08/10/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 42353
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.999	2.999	2.999	2.998	2.999
AB	0.440	0.460		0.440	0.440	0.440	0.440	0.440
AC	0.125	0.160		0.145	0.130	0.130	0.130	0.130
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.137	0.140	0.140	0.140	0.140
AG	0.140	0.160		0.145	0.143	0.143	0.148	0.146
AH	1.360	1.400		1.3745	1.375	1.377	1.377	1.376
AI	0.040	0.060		0.047	0.048	0.048	0.049	0.049
AJ	1.190	1.230		1.2135	1.216	1.215	1.216	1.216
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: DJP	Date: 08/10/16
Audited by: [Signature]	Date: 08/10/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order: 42353
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		3.000	3.000	3.000	3.000	3.000
AB	0.440	0.460		0.440	0.440	0.440	0.440	0.440
AC	0.125	0.160		0.130	0.130	0.130	0.130	0.130
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.140	0.140	0.140	0.140	0.140
AG	0.140	0.160		0.145	0.145	0.145	0.146	0.145
AH	1.360	1.400		1.376	1.376	1.376	1.376	1.376
AI	0.040	0.060		0.047	0.048	0.048	0.048	0.048
AJ	1.190	1.230		1.215	1.215	1.215	1.216	1.216
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

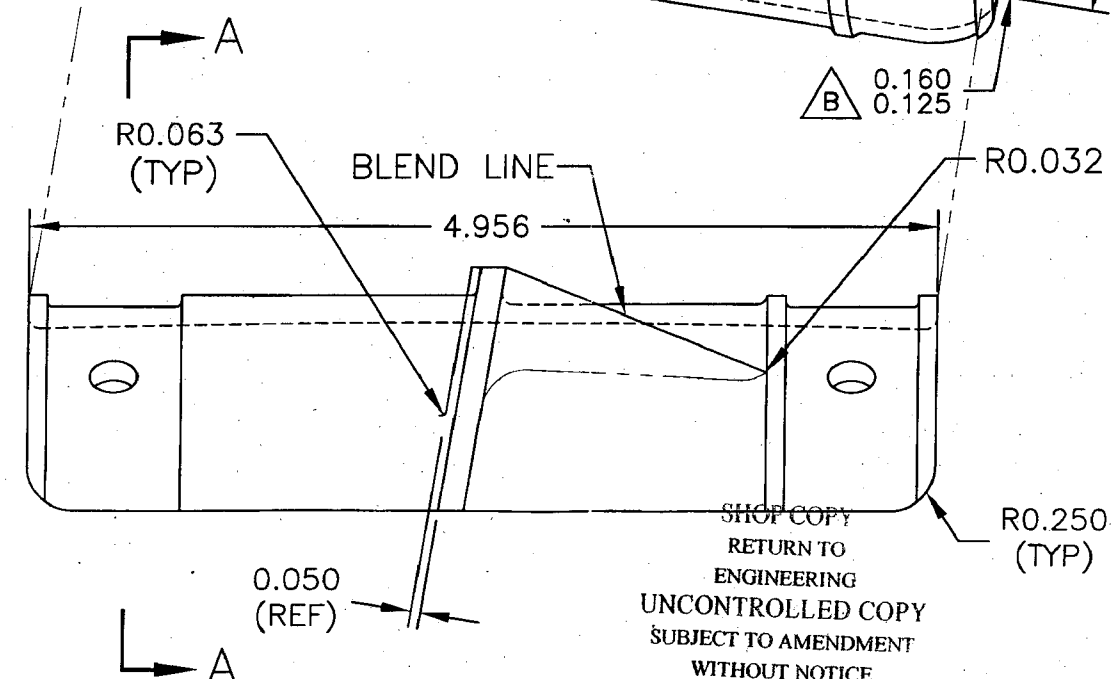
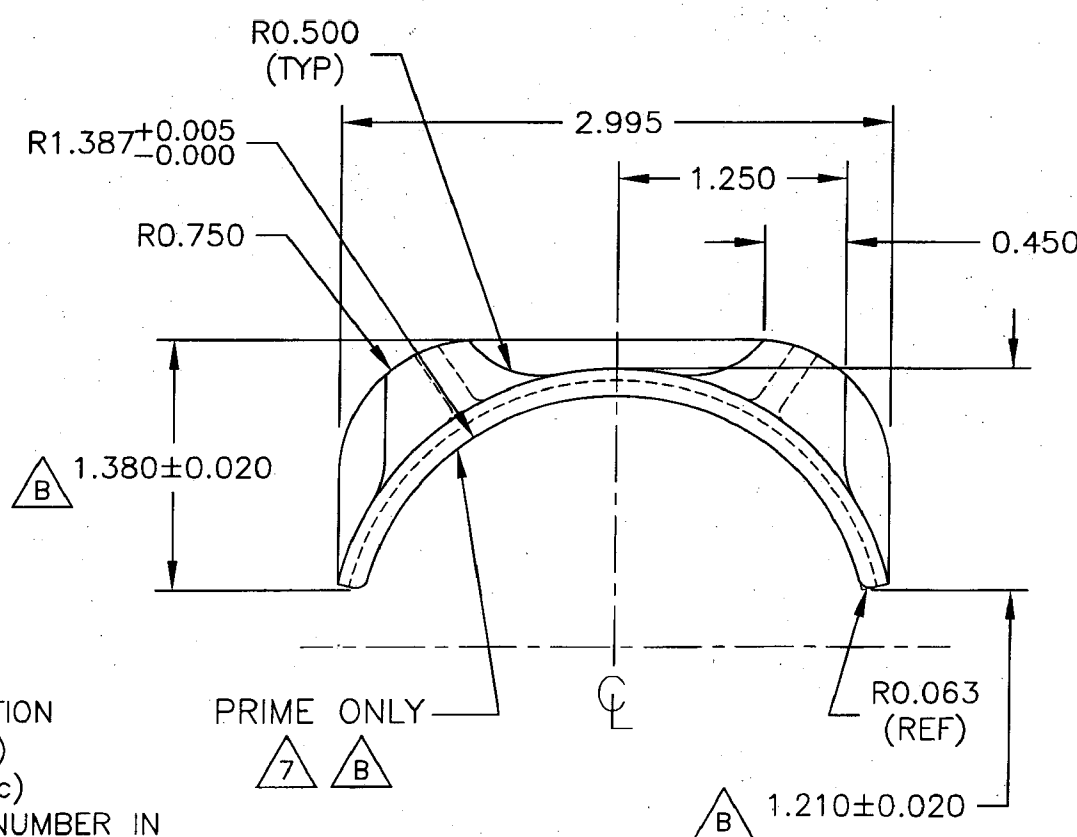
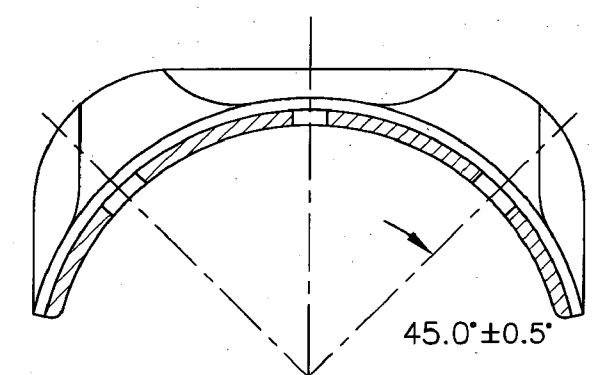
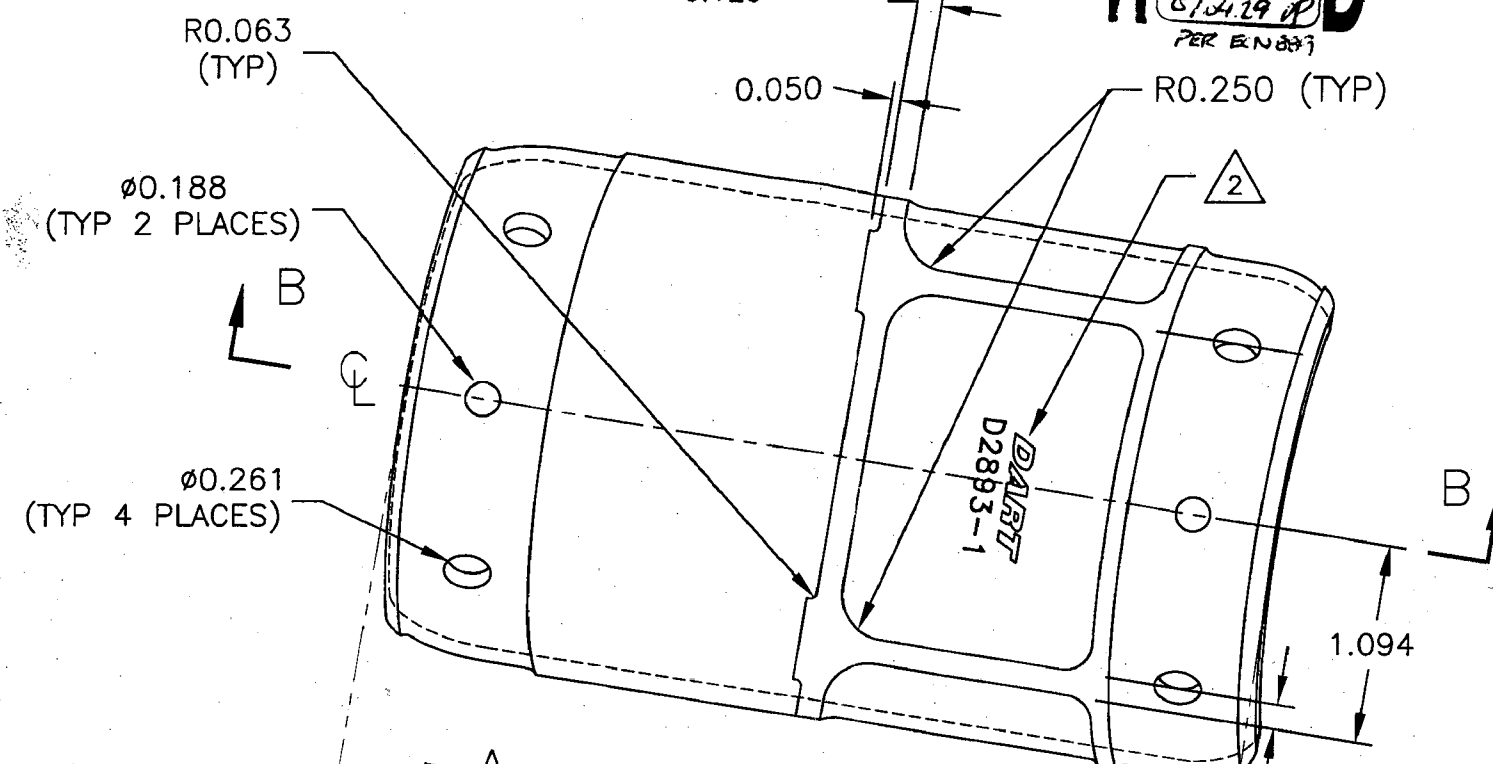
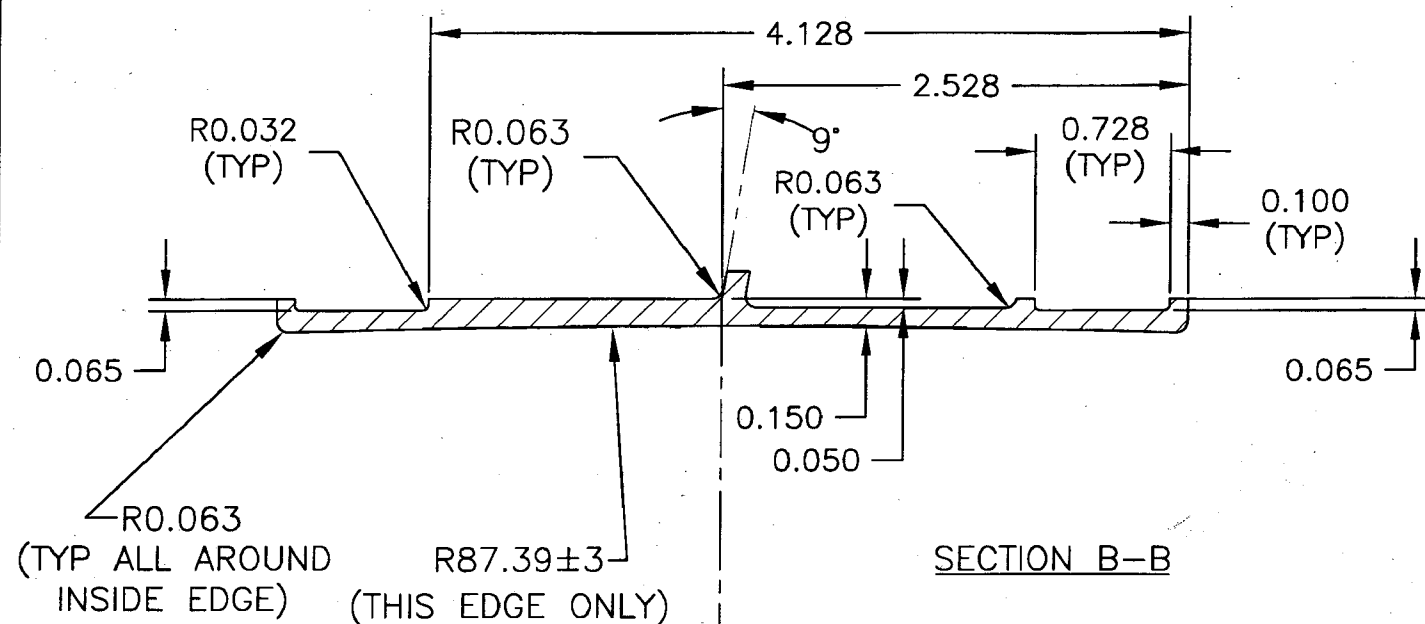
Measured by: DIP **Date:** 08/10/16

Audited by: CMX **Date:** 08/10/17

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

RELEASED
 57419 IP
 PER EN 887



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
 THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 42353

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 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	9P	DRAWN BY P/H
CHECKED	H	APPROVED H
DATE	07.03.16	TITLE
		02.750 SUPPORT
		DART HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2893
		REV. B
		SHEET 1 OF 1
		SCALE 1:1